



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

650.7711

Job Sheet 210647



Part No: 650.7711

Job Qty: 3 pcs

Part Name: Cap Retainer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/16/20

Job Tracking No:

Due Date: 7/13/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG 650.7700 REV.PF1 IPP REV:A 20.06.10 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	NV5000 - 1	3 pcs	7/6/20		1.00	1.50	NV5000 - 1	ALA
							NV5000 - 2	
110	QC 2	3 pcs	7/6/20		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	

20/07/05

20/07/05



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S286084



Part: 650.7711

Job No: 210647

Serial No/Batch: S286084

Revision: REV.PF1

Inspector:

Exp Date:

Instructions:

Date: 07/06/20

RECEIVED

134/1015

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	m/20/07/10
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
120 QC 8	3 pcs	7/6/20	0.00 0.00		QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
					GRO002-VC	5
130 Outsource - 17 - Passivate	3 pcs	7/13/20				HL 2020-07-27
140 Packaging 2-1 - Receive - B4B	3 pcs	7/13/20	0.00 0.00		Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	He MM 3 0 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	

				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 37 - B4B	
150 QC 6	3 pcs	7/13/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				QC 6 - 82	
					DAS 82 9-89 AUG 28 2020
160 Packaging 3-1 - Stock - B4B	3 pcs	7/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
					DAS 82 9-89 AUG 28 2020
170 QC 21 - SA	3 pcs	7/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
Part Op 100 - 1-Machine as per folio FD302 FOLIO REV: <u>AA</u> DWG REV: <u>PE1</u> 2-Debur Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - -Issue P/O: <u>46796</u> PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required 140 - Certificate of Conformity is required 150 - QC6- All purchased or subcontracted products 160 - Identify as per dwg & Stock 170 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303B1.000X1.000	M303B1.000 X 1.000	.5910 ft (.197 ea)	100-NV5000 - 1	<u>5191574</u>	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	M303B1.000X1.000	1	15	0
Part Specifications				
Specifications could not be found.				

Plex 6/16/20 1:26 PM Dart.Renwick.Jennifer

Entered: _____ Date: _____



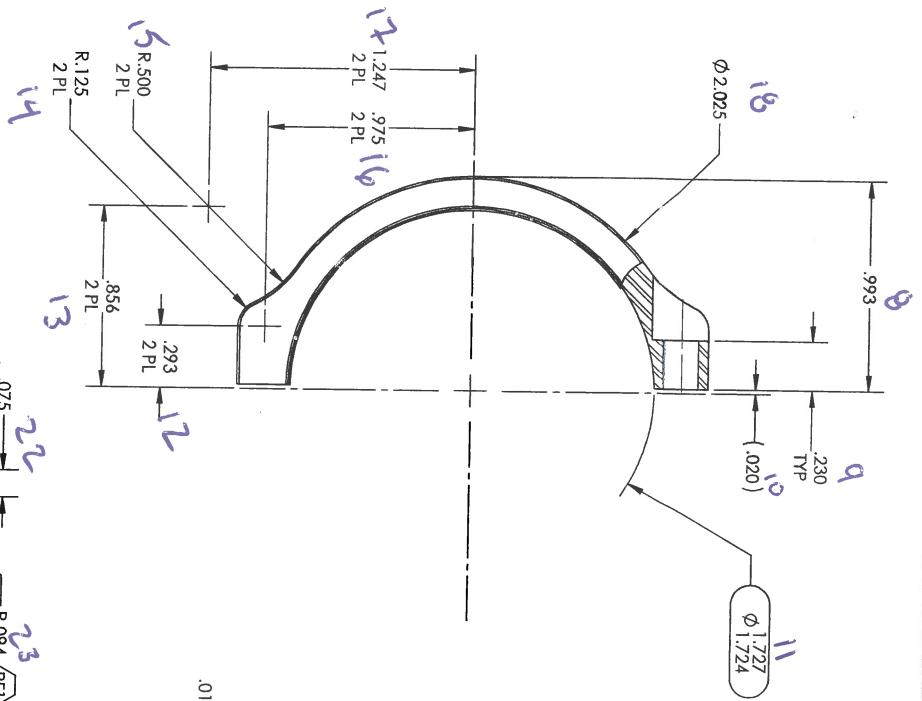
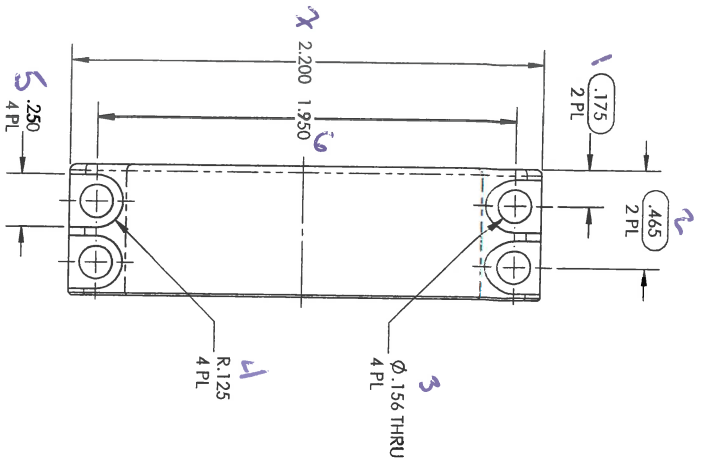
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

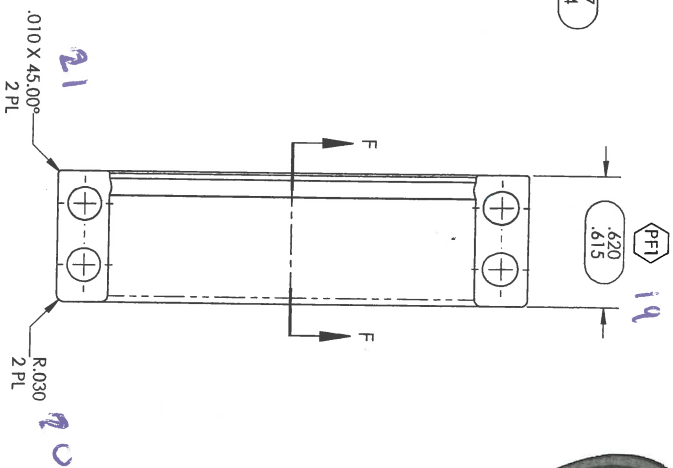
Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS				QTY Affected :		Disposition		Completed By																																																																																			
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QSI042)																																																																																			
Date : _____		Sequence #: _____		Description Work Order Deviation																																																																																											
Root Cause		<table border="1"> <tr> <td>Operator</td><td>☐</td> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> <tr> <td>Human Factors</td><td>☐</td> <td colspan="8">Other/Details:</td> <td></td><td></td> </tr> </table>										Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Human Factors	☐	Other/Details:										QC / QA Coordinator	
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																						
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐																																																																																						
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐																																																																																						
Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐																																																																																						
Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																						
Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐																																																																																						
Process Improvement	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐																																																																																								
Human Factors	☐	Other/Details:																																																																																													
												Lead hand / Supervisor																																																																																			

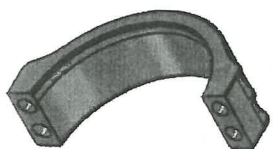
2
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APCAL INDUSTRIES, DSA, DART AND AEROSPACE. ANY REPRODUCTION IN ANY FORM
WITHOUT THE WRITTEN PERMISSION OF DART AND AEROSPACE OR APCAL INDUSTRIES IS PROHIBITED.



SECTION F-F



650.7711



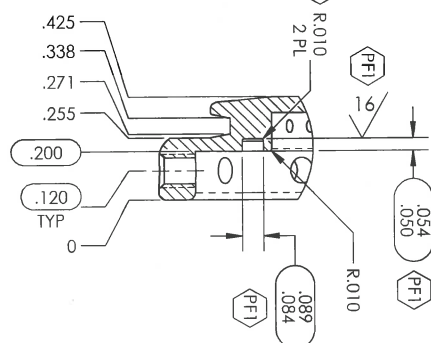
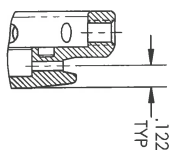
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 210647

ORIGINAL DATE: 04/12/2011	DRAWN BY: P. BAWO	CHECKED BY: P. BAWO	APCAL INDUSTRIES, DSA, DART AND AEROSPACE
DESIGNED BY: P. BAWO	APCAL INDUSTRIES, DSA, DART AND AEROSPACE	CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED TOLERANCES ARE: FRACTIONS: 1/32 DECIMALS: .005 ANGLES: 1/2°	SHEET: 8 OF 8	DWG. NO.: 650.7700	REV: PFI
SCALE: NONE	SHEET: 2 OF 4		

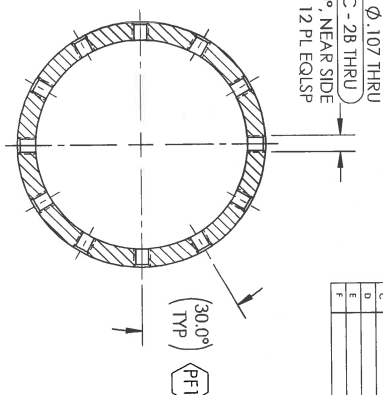
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF AEROSPACE DATA AND AEROSPACE DATA. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF AEROSPACE DATA INDUSTRIES IS PROHIBITED.

NOTES:

1. MATERIAL: 303 SS IAW AMS-5640 (25)
2. DEBURR AND BREAK ALL SHARP EDGES
3. IDENTIFY IAW MPP-120
4. FINISH: MAXIMUM UNLESS OTHERWISE SPECIFIED (22)
5. FINISH: IAW MPP-172 PASSIVATE IAW SECTION 6.1 (26)

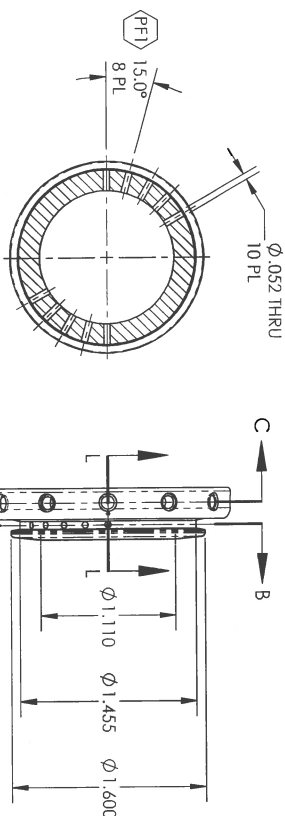


6-32 UNC - 28 THRU
 ϕ 1.50 X 90° NEAR SIDE
 12 PL EQLSP (PFI)



SECTION C-C

SECTION L-L (PFI)



SECTION B-B

PROTOTYPE REVISIONS

C

B

A

D

E

F

G

H

I

J

K

L

M

N

O

P

Q

R

S

T

U

V

W

X

Y

Z

AA

AB

AC

AD

AE

AF

AG

AH

AI

AJ

AK

AL

AM

AN

AO

AP

AQ

AR

AS

AT

AU

AV

AW

AX

AY

AZ

BA

BB

BC

BD

BE

BF

BG

BH

BI

BJ

BK

BL

BM

BN

BO

BP

BQ

BR

BS

BT

BU

BV

BW

BX

BY

BZ

CA

CB

CC

CD

CE

CF

CG

CH

CI

CJ

CK

CL

CM

CN

CO

CP

CQ

CR

CS

CT

CU

CV

CW

CX

CY

CZ

DA

DB

DC

DD

DE

DF

DG

DH

DI

DJ

DK

DL

DM

DN

DO

DP

DQ

DR

DS

DT

DU

DV

DW

DX

DY

DZ

EA

EB

EC

ED

EE

EF

EG

EH

EI

EJ

EK

EL

EM

EN

EO

EP

EQ

ER

ES

ET

EU

EV

EW

EX

EY

EZ

FA

FB

FC

FD

FE

FG

FH

FI

FJ

FK

FL

FM

FN

FO

FP

FQ

FR

FS

FT

FU

FV

FW

FX

FY

FZ

GA

GB

GC

GD

GE

GF

GG

GH

GI

GJ

GK

GL

GM

GN

GO

GP

GQ

GR

GS

GT

GU

GV

GW

GX

GY

GZ

HA

HB

HC

HD

HE

HF

HG

HH

HI

HJ

HK

HL

HM

HN

HO

HP

HQ

HR

HS

HT

HU

HV

HW

HX

HY

HZ

IA

IB

IC

ID

IE

IF

IG

IH

II

IJ

IK

IL

IM

IN

IO

IP

IQ

IR

IS

IT

IU

IV

IW

IX

IY

IZ

JA

JB

JC

JD

JE

JF

JG

JH

JI

JJ

JK

JL

JM

JN

JO

JP

JQ

JR

JS

JT

JU

JV

JW

JX

JY

JZ

KA

KB

KC

KD

KE

KF

KG

KH

KI

KJ

KK

KL

KM

KN

KO

KP

KQ

KR

KS

KT

KU

KV

KW

KX

KY

KZ

LA

LB

LC

LD

LE

LF

LG

LH

LI

LJ

LK

LL

LM

LN

LO

LP

LQ

LR

LS

LT

LU

LV

LW

LX

LY

LZ

MA

MB

MC

MD

ME

MF

MG

MH

MI

MJ

MK

ML

MM

MN

MO

MP

MQ

MR

MS

MT

MU

MV

MW

MX

DART AEROSPACE LTD		Work Order:	210647
Description: CAP		Part Number:	650-7700
Inspection Dwg:	Rev: PF1	Page 1 of 1	

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	.175	±.005	.174	/		VERN.	B18017739
2	.465	±.005	.465	/		"	"
3	Ø.156	+0.005 / -0.001	.156	/		"	"
4	R.125	±.005	R.124	/		R6	REF
5	.250	±.005	.250	/		VERN.	B18017739
6	1.950	±.005	1.951	/		"	"
7	2.200	±.005	2.200	/		MIC	67450464
8	.993	±.005	.9925	/		DIAL	milling
9	.230	±.005	.229	/		VERN.	B18017739
10	.020	±.005	AS PER CAD	/			
11	1.724 / 1.727	—	1.726	/		DIAL	milling
12	.293	±.005	AS PER CAD	/			
13	.856	±.005	AS PER CAD	/			
14	R.125	±.005	R.125	/		R6	Ref.
15	R.500	±.005	R.500	/		R6	Ref.
16	.475	±.005	AS PER CAD	/			
17	1.247	±.005	AS PER CAD	/			
18	Ø2.025	±.005	AS PER CAD	/			
19	.615 / .620	—	.618	/		MIC	67449274
20	R.030	±.005	.031	/		R6	Ref.
21	.010 X 45°	±.005	.011	/		VERN.	B18017739
22	.075	±.005	.076	/		"	"
23	R.094	±.005	.0938	/		R6	Verified on forming tool
24	.008 / .010	—	.0085	/		DIAL	milling
25	303SS AMS-5640		AMS-5640	✓		MILL TEST	HIT 446294
26	PASSIVATE			✓		C OF C	ALTECH
27	✓63			✓		SURFACE FINISH COMPARATOR	

Measured by: ALA	Checked by: [Signature]	QC Inspector:	82
Date: 20/07/05	Date: 20/07/10	Date:	AUG 28 2020

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046796

PO Date: 7/27/20

Due Date: 8/4/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-07-28

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211477	650.6511	650.6500 REV.PB2	Fill Port Adapter -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X5	-	8/4/20	5 pcs	0 pcs	5 pcs	\$4.7619/pcs	\$23.81
2	210873	650.6213	650.6200 REV.PE1	Banjo -10 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel -Certificate of Conformity is required	Firmed X2	-	8/4/20	2 pcs	0 pcs	2 pcs	\$4.7619/pcs	\$9.52



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	210872	650.6210	650.6200 REV.PE1	BANJO -4 -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H1150 stainless steel -Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
4	211168	650.6312	650.6300 REV.PG2	Screen Retainer -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
5	210647	650.7711	650.7700 REV.PF1	Cap Retainer -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29

DAS
82
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046796



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	210875	650.6316	650.6300 REV.PG2	Swivel Fitting -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X2	-	8/4/20	2 pcs	0 pcs	2 pcs	\$4.7619/pcs	\$9.52
7	211167	650.6310	650.6300 REV.PG2	Swivel Fitting -Issue P/O; PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 17-4PH H900 stainless steel - Certificate of Conformity is required	Firmed X3	-	8/4/20	3 pcs	0 pcs	3 pcs	\$4.7619/pcs	\$14.29
Grand Total:												\$100.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/28/20 1:48 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



0 2 9 8 6 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868

www.groupaltech.com

Bon de Livraison / Packing Slip

029869 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
28-Jul-2020		Ian Wilson		POHB046796					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	650.6511 Rev.PB2	650.6511 01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	5	5	0	0	0	
2	650.6213 Rev.PE1	650.6213 01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	2	2	0	0	0	
3	650.6210 Rev.PE1	650.6210 01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0	

RECEIVED

JUL 29 2020

DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance



0 2 9 8 6 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

029869 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Jul-2020		Ian Wilson		POHB046796				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	650.6312 Rev.PG2	650.6312 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0
5	650.7711 Rev.PF1	650.7711 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0
6	650.6316 Rev.PG2	650.6316 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	2	2	0	0	0


Certificat de Conformité / Certificate of Compliance


0 2 9 8 6 9 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip
029869 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Jul-2020		Ian Wilson		POHB046796				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
7	650.6310 Rev.PG2	650.6310 01-PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST REF:-PASSIVATION ASTM A380-PASSIVATION AMS 2700/QQ-P-35, PASSIVATION ASTM A967. Precleaning with rags and solvent if required remove any markings, paintor and heavy contaminants. 02 - Dégraissage Acier tout alliage 03 - Décapage et désoxydation des aciers inoxydables selon ASTM A967 et A380 04 - Passivation des aciers inoxydables selon ASTM A967-13, ASTM-A380-13 05 - Emballage et identification des pièces	PASSIVATION CH	3	3	0	0	0

RECEIVED

JUL 29 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes**Epaisseur réelle
Actual Thickness**
**Inspecteur Qualité
Quality Inspector**
**Réçu par
Received By**

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

26839 N

Management Systems
Certified by
LRQA
ISO 9001 / SGI 6000360
ISO 14001 / SGI 1570678

OLARRA

3

Date - Datum - Fecha
20 - 02 - 2018

Your order N°
Bestell - Nr
Pedido N°

Vm

According to
Entsprechend
Corresponds

ASTM A 582 A 582M-12.

Tolerance - Toleranz
Tolerancia
ASTM A 484 /TB.8

Bundles		Bars		Weight	
Bunde	2	Stabe	55	Gewicht	2518 Lbs
Bultos		Barra		Peso	

Requirements - Anforderungen - Experiencias

Heat treatment / Wärmebehandlung / Tratamiento térmico
1050C 4H/Std WATER/WASSER/AGUA

Solution annealed/Abgeschreckt/Hipertempe-Cold drawn/Gezogen/Estirado

Test results - Ergebnis der Prüfungen - Resultados de los ensayos

Dimension of Specimen Abmessung des Probestabes Medida de las probetas		Rp0.2% KSI	Rp 1% KSI	Rm KSI	A %L 5D	A %L 4D	Z %	Hardness Härte HBw	Impact test / Kerschschlag / Resiliencia ISO V ft. lb.
RD. 12,50 mm.		Mn.							
		Max.						262	
Temperature °C 20	Spec. N° Probe Nr. Pro N°	1	58	69	94	48	57	197	

	C	Si	Mn	P	S	Cr	Mo	Ni	Cu	N	Co
Min					0,150	17,00		8,00			
Max	0,150	1,00	2,00	0,200		19,00		10,00	0,70	0,1000	
	0,042	0,38	1,78	0,032	0,199	17,65	0,28	8,45	0,40	0,0400	0,15

Visual and dimensional inspection Besichtigung und Ausmessung Control visual y dimensional	O.K.	Radioactivity inspection Radioaktivitätskontrolle Control de Radioactividad	O.K.	Antirimb test Spieldruck Verwechslungspr. Antimozzia	O.K.	Grain Size Korngrösse Tamaño de grano
--	------	---	------	--	------	---

Remarks - Bemerkungen - Observaciones

Free From Mercury contamination/Quecksilberfreiheit.
No weld repair.

EDV / EDP
Acc. EN 10.204
Marian Tejedo
Quality Mng.

Works Inspector
Der Werkssachverständige
Inspector de fábrica

We hereby certify that material described herein complies with the requirements agreed on the order.

Firmado digitalmente por / Signed digitally by:
ACEROS INOXIDABLES OLARRA SA - CIF A48863548
Fecha / Date: 20-02-2018 16:18

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M30381.000X1.000

PO / BATCH NO.: PO113043676/

DATE: June 18 2019

5191574

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 1"

QUANTITY RECEIVED: 13.5ft

THICKNESS RECEIVED: 1"

QUANTITY INSPECTED: 13.5ft

SHEET SIZE ORDERED: -

QUANTITY REJECTED: -

SHEET SIZE RECEIVED: -

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	ASTM A582
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HT:446294
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>Um</u>	DAS <u>61</u>	SIGNED OFF BY: _____	
DATE: <u>June 18 2019</u>	9-80	DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

